

Date: Tuesday, 04/11/2008 8:34:14 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : REAR OVERHEAD R/H
 Job Number : 43180
 Estimate Number : 13590
 P.O. Number :
 This Issue : 04/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R&D THERMOFORMING
 Previous Run : 42072
 Written By :
 Checked & Approved By :
 Comment : Est. A New Issue 08/09/17 DL

Part Number : D38232
 Drawing Number : D38232 UNDER REVIEW 07-11-06 Ht
 Project Number : IN0002
 Drawing Revision : A UNDER REVIEW
 Material : MKYDEX6185S80P362015
 Due Date : 14/11/2008 Qty: 2 Um: Each

PROTOTYPE
 PLEASE RETURN ALL ISSUED DATA TO ENGINEERING
 04/11/2008 DL

POSITIVE RECALL apnol.

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MKYDEX6185S80P362015 Kydex velour matte, ivory



Comment: Qty.: 11.3747 sf(s)/Unit Total : 22.7493 sf(s)
 Kydex velour matte, ivory

M 109703

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

08/11/04 Ht.

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/04

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-2 and folio (FTA 9113 Prototype) using tool DT 9113

Dwg. Rev. A UNDER REVIEW.
 Folio Rev. A.

08/11/04

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 04/11/2008 8:34:15 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD R/H

Job Number: 43180

Part Number: D38232

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



08.11.26 (2)



PTC

Comment: SECOND CHECK

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

08/11/27 (12)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



08.12.01

Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.01 Promtype

Job Completion



U 08.12.24

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

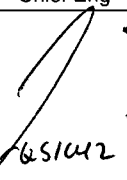

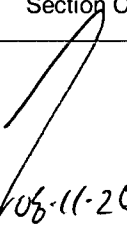
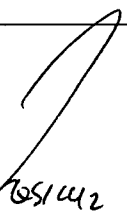
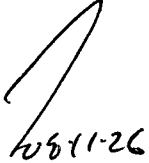
DATE

cancel

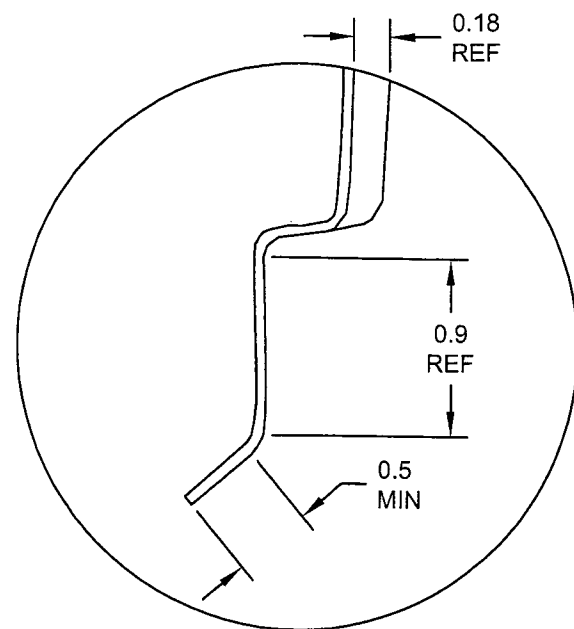
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

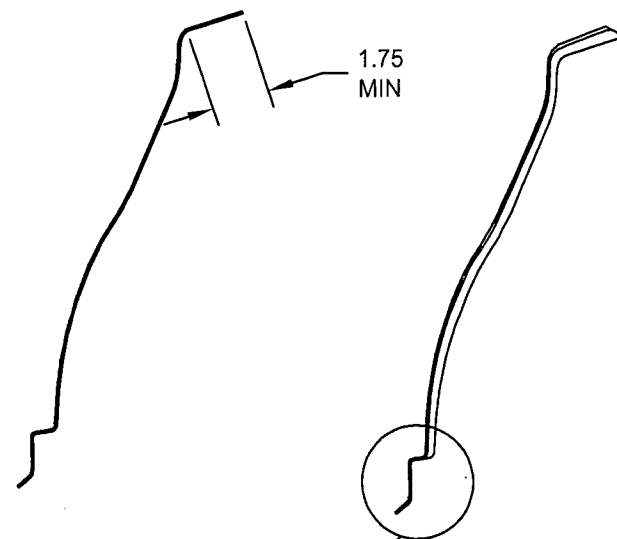
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/26	6.0	1 part, the 0.9 dim is cut to approximately 0.500" removing the other 0.500" flange.		Part is for testing only and this area is for fasteners. Should be acceptable for testing.	 08/11/26	 08/11/26	 08/11/26	 08/11/26
				USE FOR HAA Setup 08.12.01				

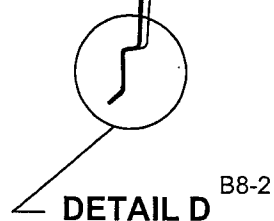
NOTE: Date & initial all entries



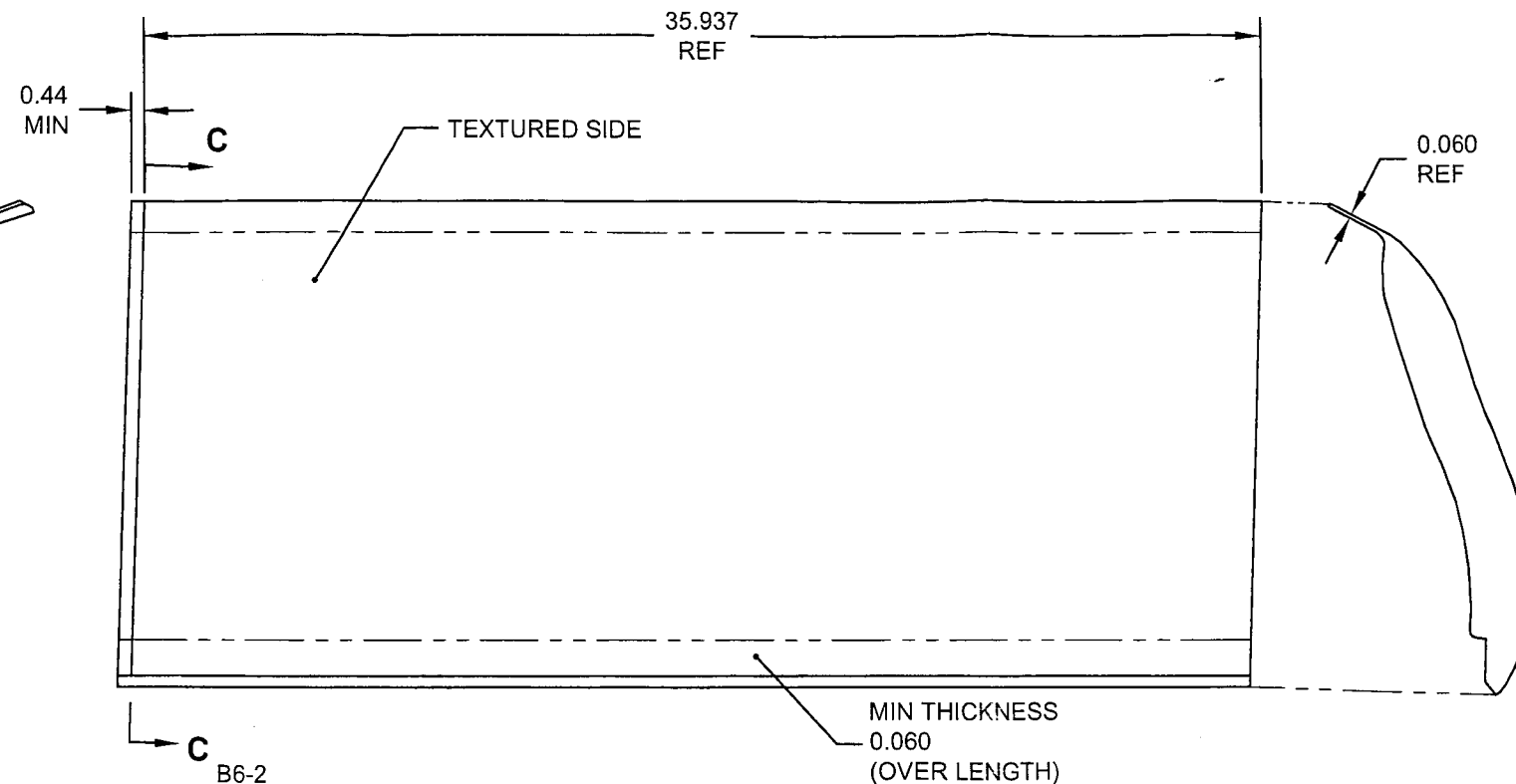
DETAIL D B5-2
SCALE 5X



SECTION C-C B4-2



DETAIL D B8-2



D3823-2 REAR OVERHEAD, RH

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

01.11.06 *RET*

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3823-2" USING VIBRATING STYLUS
- 7) WEIGHT: 2.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9113 PER DART QSI 022. TRIM PER MOLD

DESIGN	<i>PU</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RET</i>		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3823	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD	NTS
DATE	08.09.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order: 43181
Description: Rear Overhead RH / Prototype		Part Number: D3823-2
Inspection Dwg: D3823 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			Nada

Measured by: <i>[Signature]</i>	Date: 08.11.04
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.9 (Ref)		0.9	✓			
0.5	± 0.100	0.5	✓			
1.75"	± 0.030	1.75	✓			
0.44	± 0.030	0.44	✓			
35.937 (Ref)		35.937	✓			This should not be a Ref dim
0.06 min	min	0.070	✓			

Measured by: <i>[Signature]</i>	Date: 08.11.26
Audited by: <i>[Signature]</i>	Date: 08.11.26
Prototype Approval: <i>[Signature]</i>	Date: 08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Date:

8/10/24

Batch No:

M109703

Supplier:

SABIC

Dart P/O:

7280

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Location



SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

59 8000/27

08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER